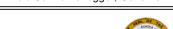
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



OBG cross beams and suspension brackets

Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-005491 Address: 333 Burma Road **Date Inspected:** 23-Feb-2009

City: Oakland, CA 94607

34-0006

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name: CWI Present: Yes Yu Dong Ping No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No N/A **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No

Yes No N/A **Delayed / Cancelled:**

Component:

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG bay 19

Bridge No:

This QA observed ZPMC qualified welding personnel identified as Mr. Chen Zhoushan (062750) and Mr. Wang Yong (062807) perform FCAW welding on suspension bracket identified as SB004-012. ZPMC QC identified as Mr. Xu Tao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as Mr. Zhang Chao (062739) and Mr. Xie Biwu perform FCAW welding on weld joint identified as FB209-1-002-084 and 050. ZPMC QC identified as Mr. Xu Tao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as Mr. Han Zejiao (062808) and Mr. Fei Xiang (062751) perform FCAW welding on suspension bracket identified as SB002-012. ZPMC QC identified as Mr. Xu Tao was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as Mr. Xu Aihua (062816) perform SAW welding on weld joints identified as BP-026-002-002, BP027-001-001 and BP025-009-001. ZPMC QC CWI

WELDING INSPECTION REPORT

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identified as Mr. Yu Dong Ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Yulong (062817) perform SAW welding on weld joint identified as BP-025-003-003. ZPMC QC CWI identified as Mr. Yu Dong Ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2c-S-2.

This QA observed ZPMC qualified welding personnel identified as Mr. Liu Changqing (062755) perform FCAW (root) welding on weld joint identified as BP-028-001-001. ZPMC QC CWI identified as Mr. Yu Dong Ping was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA observed ZPMC personnel tack welding various cross beam bottom panel splice joints and suspension brackets. ZPMC QC CWI identified as Mr. Yu Dong Ping was present to monitor the tack welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with the applicable WPS.

This QA observed ZPMC personnel flame straightening suspension bracket flange distorted by the welding process. The flame straightening process appeared to be in general compliance with ZPMC flame straightening procedure outlined in the contractors WQCP section 11.

OBG outside assembly segment (3AW, 3BW and 5AE)

No work being performed on these segments while QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.





Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By: Hall,Steven Quality Assurance Inspector

Reviewed By: Carreon, Albert QA Reviewer